

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73779



Page 2

Thursday, September 15, 2011 10:25:05 AM

Item ID:	D6101-001	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle Billet					
Start Date:	9/16/2011	Start Qty:	60.00		Cust Item ID:	
Required Date:	11/4/2011	Req'd Qty:	60.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo Ensure Material certification comply to Dwg D	0.00		and 10/10/25		60	0		
130 	Identify as per dwg & Stock Location: 1A140	0.00		and 11/10/25		60	0		
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/10/26
MF 11-10-25

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 15, 2011 10:25:03 AM

Page 1

Work Order ID: 73779

Parent Item: D6101-001

Parent Item Name: Saddle Billet



Start Date: 9/16/2011

Required Date: 11/4/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP B: ☐01.05.04☐New Issue☐EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001P

Purchased

No

110

Each

0.0000

1

60



7075-T7351 2X6X6.25



Perth
11/4/25 (60)

W/O:		WORK ORDER CHANGES					
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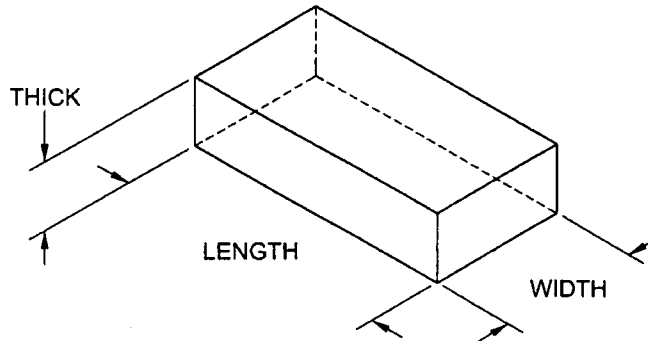
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SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ **B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ **B**

W 073779

RELEASED
09/07/15/WP

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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**Castle Metals®**

A. M. Castle & Co.

BORDEREAU DE MARCHANDISES

Page 1 of 1

No de Formulaire d'Emballage / Pack Slip No:812188

Expédié de / Ship From: A. M. Castle & Co. Connecticut - Ext 12 Cascade Boulevard Orange, CT 06477		Vendu à / Sold To: A. M. Castle & Co. (Canada) Inc. DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Expédié à / Ship To: WILL CALL-MONTREAL 835 SELKIRK AVENUE POINTE CLAIRE, QC H9R 3S2 CA		Livré à / Deliver To: A. M. Castle & Co. (Canada) Inc. WILL CALL-MONTREAL 835 SELKIRK AVENUE POINTE CLAIRE, QC H9R 3S2 CA	
Date d'expédition / Date Shipped	F.O.B.	Modalités de transport / Freight Terms		Transporteur / Carrier		No du Bon de connaissance / BOL No	N° de livraison / Delivery No
17-OCT-2011	ORIGIN	Prepaid		CASTLE_NETWORK K		816670	99063310

Détails d'expédition / Shipment Details	Destination finale / Final Destination Branch -
--	--

N° de commande / Order No	N° de ligne / Line No	N° d'article / Item No	Description	
1745775	1	752237.MO	2.0000.PL.7075.T7351.ALUMINUM.US1.48.5000.144.5000 CUT 2SIDED.TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12	
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number	Qté commandée / Ordered Qty	Qté Facturée / Invoice Qty
14899		YOUR ITEM NUMBER: D6101-001	60.00 PCS	60 PCS

Détails / Details						
Usine / Mill	No de coulee / Heat Number	Code méc / Mech Id	Pièces / PCS	Largeur (Pouce) / Width (IN)	Longueur (Pouce) / Length (IN)	Qté expédiée / Shipped Qty (LBS)
	469765A2		60			464.5

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Ce matériel a été reçu et inspecté par
Reviewed by Authorized Castle Metals Representative:

Date:

Name:

SHIP TO:

CASTLE METALS AEROSPACE
15 EXECUTIVE BLVD.
ORANGE, CT 06477

KAISER ALUMINUM

Trenwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

CAS AERO% A M CASTLE METALS
ATTN:BOB OHR % ACCTS PAYABLES
3400 NORTH WOLF RD
FRANKLIN PARK, IL 60131

CERTIFIED TEST REPORT

Serial Number

4161161

CUSTOMER PO NUMBER: 8352		WORK PACKAGE:	CUSTOMER PART NUMBER: 752237 AMC CA-15745		SHIP RUN/LOAD ID: 101527/11	GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1082355	LINE ITEM: 1	SHIP DATE: 29-APR-2009	ALLOY: 7075	CLAD: BARE	TEMPER: T351	PRODUCT DESCRIPTION: Sawed Plate	
WEIGHT SHIPPED: 8598 LB	QUANTITY: 6 PCS EST.	B/L NUMBER: 2022480	GAUGE: 2.0000 IN	WIDTH: 48.500 IN		LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG/Amd1

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 4697B5A2 Cast 222

Drop 37

Ingot 1

(ASTM E8/B567)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.4 : 73.5 (506 : 507)	11.6 : 81.6 424 : 426)	12.3 : 12.6

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	40.2 Min	0.4 Max
(MS/M) :	23.3 Min	3.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.07	0.13	1.4	0.04	2.5	0.18	.8	0.02	0.01	0.01	TOT 0.04

